

22

W/O SPLIT

DART AEROSPACE LTD	Work Order:	20832 B
Description: Bushing/Nut	Part Number:	D3176-1/-3
Dwg: D3176 Rev. A	Qty:	20
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller			
2	MC	Turn blank per Dwg D3176 and Folio FA286 & FA287 Material: AISI 303 SS (Ref: Dart Spec: M303R1.000) thread per MIL-S-7742 Batch: M15267	SL	04/08/20	
3	QC2	Inspect parts as they come off the CNC machine	SL	04/08/20	
4	MV	Cut head as per Dwg D3176 and Folio FA286 & FA287	ml	04/09/20	26
5	QC2	Inspect parts as they come off the CNC machine	SL	04/08/20	
6	MV	Deburr and Tumble. Cover D3176-1 thread using D3176-3 nut	SL	04/09/20	26
7	QC8	Second check			
8	FP	Identify and Stock	destroyed ml	05/08/05	13
9	AC	Cost / part 12.40	Sur	05-08-02	
10	DC	Close W/O Inspect Level 21			

PTO

Rev	Date	Change	Revised By	Approved
A	02.11.04	New issue	KJ RF	

RELEASED
02/11/04 RF

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
0508-04	3	Threads are incorrect	VB 05/08/07	Scrap & destroy all Person no longer works here	ml 05-08-05	VB 0508-04	VB 05/08/07	VB 0508-04

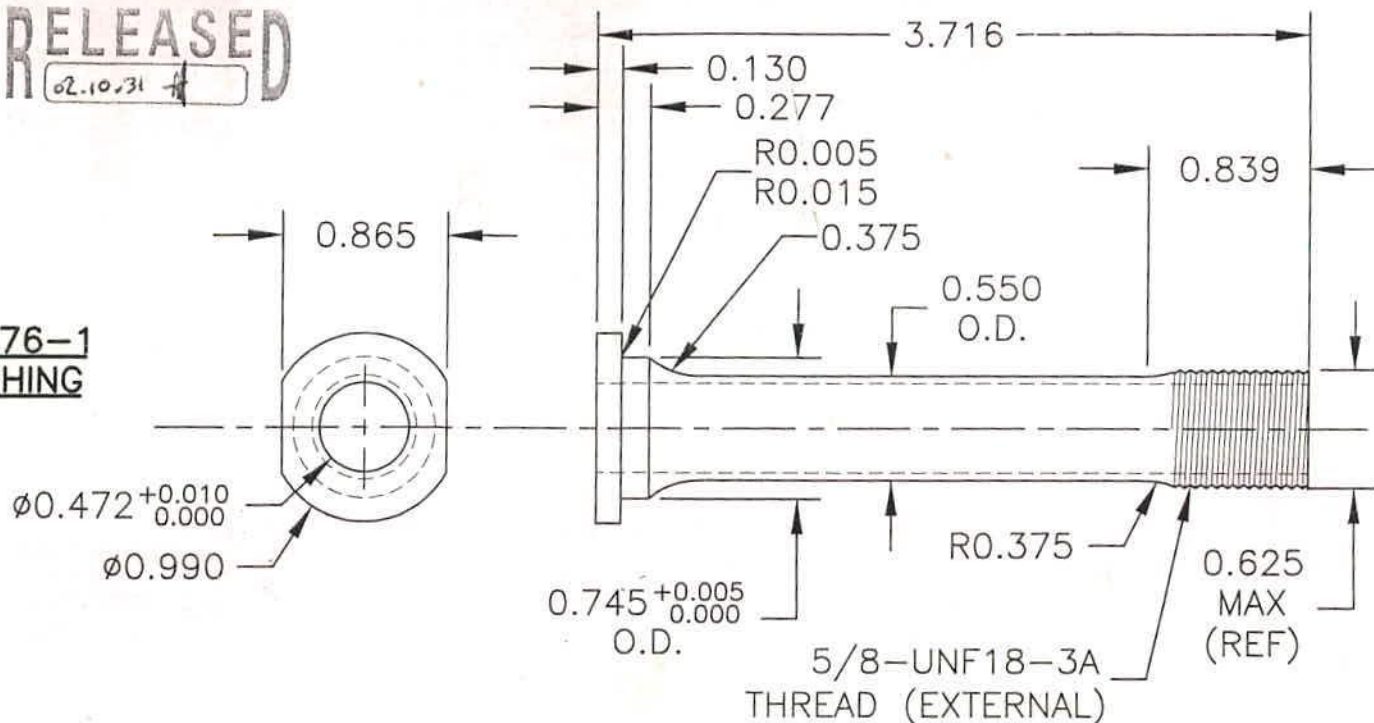
PAR#: N/A Fault Category: N/A DQA: 19 Date: 05/08/07



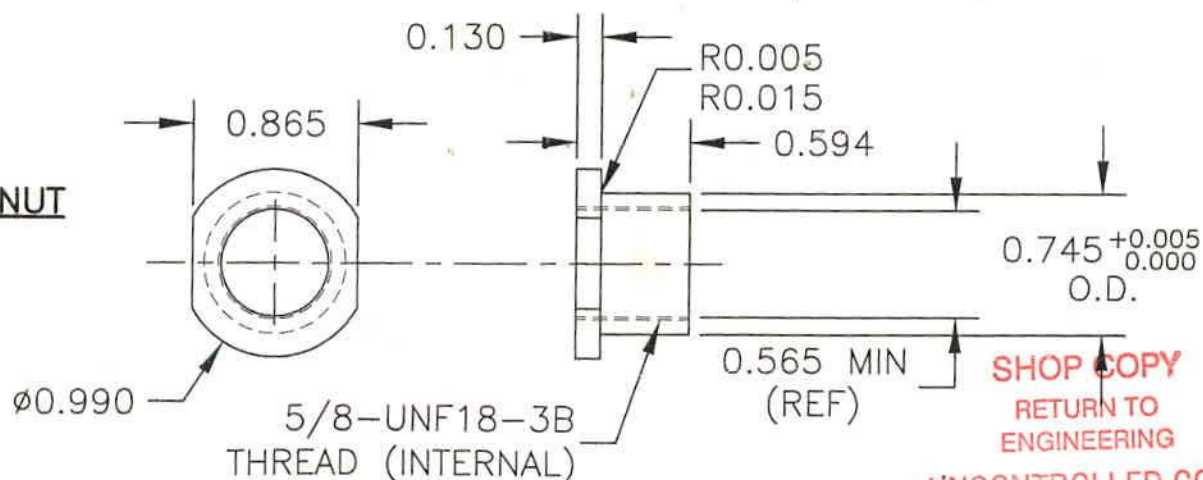
DESIGN KJ	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

RELEASED
02.10.31

**D3176-1
BUSHING**



D3176-3 NUT



D3176-1/-3

- 1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
- 2) THREADS PER MIL-S-7742
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) FINISH: NONE
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) D3176-1/-3 ARE MATING PARTS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20832

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2004
10:55 am

Work Order No : 0020832
Project Name : D3176-1
Project For : WK422
Work Order Type : Main
Main WO Number :
House Part Number : D3176-1
Description : Bushing
Manufactured : Yes
Amount Req'd : 10 20
Amount Done : 0
Start Date : 05-06-04
Est Finish Date : 05-28-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00